

# Work Order ID 58597

May 12, 2010 10:25:39 AM



Page 1

Item ID: D3187-1

Accept



Setup Start



Revision ID:

Item Name: Spacepod Floor

Stop



Start Date: 12/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 18/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 10/5/12 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3187

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3187 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-  
Deburr if necessary

B10-5-07

6061 .050

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

\*\*\*TEMPLATE DT3187-1T1\*\*\*

B10-5-07

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/12/25

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

May 12, 2010 10:25:39 AM



**Accept**

**Setup Start**

**Stop**



**Start Date:** 12/05/2010    **Start Qty:** 4.00

**Cust Item ID:**

**Required Date: 18/05/2010      Req'd Qty: 4.00**



**Customer:**

**Reference:**

Run Start



**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00



### Small Fab

## Small Fab

## Memo

0.00

## Small Fab

1- install D2986-1 rubber spacer using contact cement and trim to fit if necessary as per dwg D3187□A/R contact cement Batch: 112983 □2- transfer holes from spacepod floor to rubber spacer

ET 10-06-08

0.00



QC5- Inspect part completeness to step on W/O

QC

## Memo

0.00

## Quality Control

Swoblos

44

0.00



Identify as per dwg & Stock Location: 291

### Packaging

## Memo

0.00

## Packaging

X4 BB 10/06/10

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**Work Order ID 58597**

May 12, 2010 10:25:39 AM



Page 4

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Setup Start



Revision ID:

Item Name: Spacepod Floor

Stop



Start Date: 12/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 18/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/10

PL 10-6-10  
(4)

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NOTE: Date & initial all entries



May 12, 2010 10:25:44 AM

\_\_\_\_\_



**Required Date:** 18/05/2010

**Required Qty: 4.00**

\_\_\_\_\_

### Rubber Spacer

B59409 +



81 10-06-08

**Loc Code**

ST242

5

57659

5

M6061T6S.050

Purchased

No

160

sf

72,0000

7.43



6061-T6 .050 Sheet

**Loc Code**

MAT21

72

110791

5

113216

64

17349

3

113216

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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WITHOUT NOTICE

WORK ORDER

NO. 58797

BS10-5-12

D2986-1 RUBBER  
SPACER

Ø0.250  
28 PL

Ø0.19  
8 PL

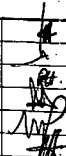
53.44

RELEASED  
09.01.05 MB

# D3187-1 SPACEPOD FLOOR

## **D3187-1 SPACEPOD FLOOR NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.2 LBS
- 8) TOOLING: CUT/DRILL PER TEMPLATE DT3187-1T1
- 9) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT

C	REDRAWN TO CURRENT STANDARDS; TRANSFERRED TO B-SIZE FORMAT; ADDED SHEET 2, CREATED DETAIL FOR D3187-2, REVISED SHEET 1 NOTES. REASON: CLARIFIED DRAWINGS FOR D3187-1/-2.	MB	09.01.05	
B	CHANGE SHAPE	CP	03.05.16	
A	NEW ISSUE	CP	03.03.31	
REV.	DESCRIPTION	BY	DATE	
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN		DRAWING NO. D3187	REV. C	
CHECKED			SHEET 1 OF 2	
MFG. APPR.			SCALE	
APPROVED		TITLE SPACEPOD FLOOR	NTS	
DE APPR.		COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DATE		09.01.05		

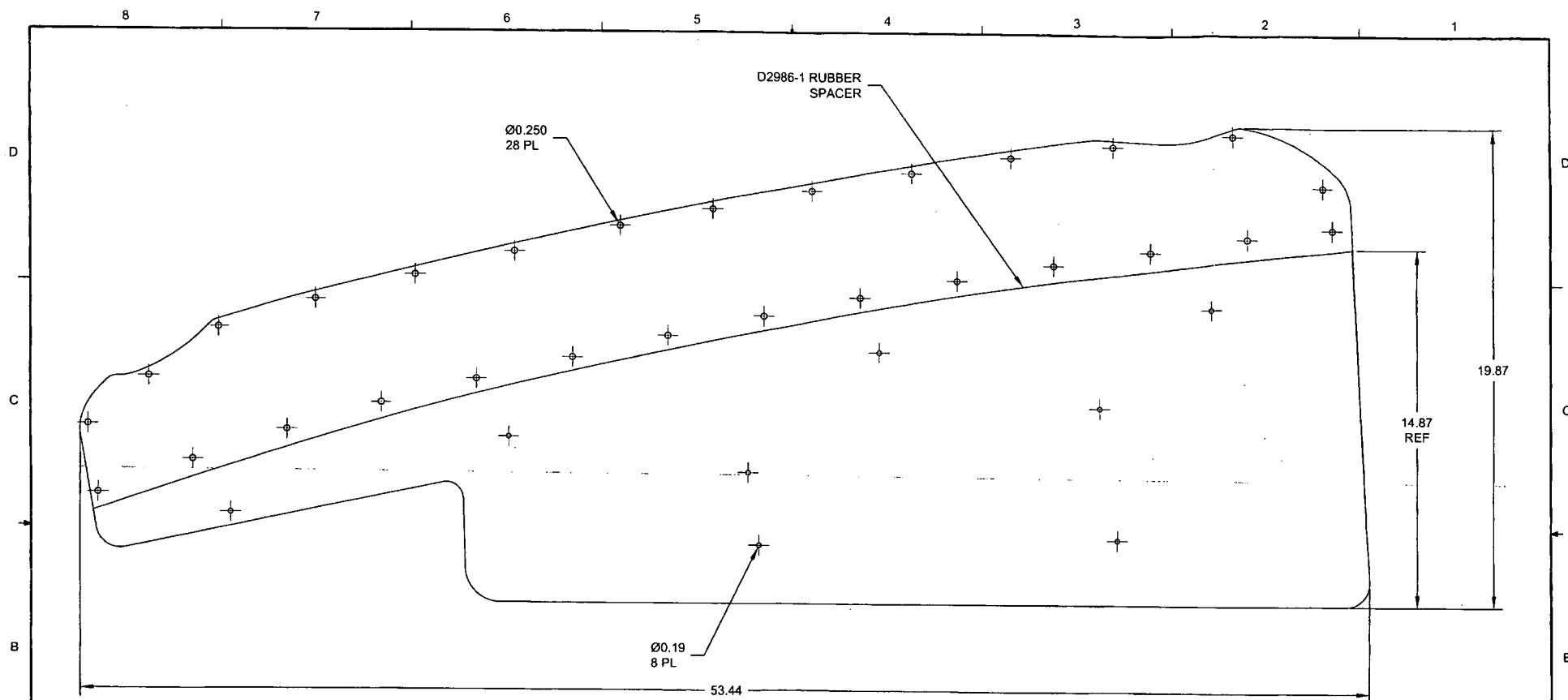
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**NOTE:** Date & initial all entries









**D3187-2 SPACEPOD FLOOR**

**D3187-2 SPACEPOD FLOOR NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-2" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.2 LBS
- 8) TOOLING: CUT/DRILL PER TEMPLATE DT3187-1T1
- 9) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT

W1058597

**RELEASED**  
09.01.05

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3187	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD FLOOR	NTS
DATE	09.01.05	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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